

Tuesday, April 14, 2015 1:42:43 PM

Page 1

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval			
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

Work Order ID 131558

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131558

Page 2

Item ID: D412-709-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 4/14/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/17/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-709-011								
	Location: <u>002</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

15-04-22 SL

NLS 15-04-23

15-4-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

Picklist Print

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Page 1

Work Order ID: 131558

131558

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 4/14/2015

Required Date: 4/17/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC IPP Rev:D
10.05.20 added D3561-1 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-20A *AN6-20A* BOLT		Purchased	No			110	Each	39.0000	3	3			
											**		
											DAS		
											27		
											9-39		
											APR 15 2015		
D3118-3 *D3118-3* Sign Assembly		Manufactured	No			110	Each	1.0000	1	1			
											**		
											DAS		
											27		
											9-39		
											APR 15 2015		
D3224-1 *D3224-1* Frame		Manufactured	No			110	Each	9.0000	1	1			
											**		
											DAS		
											27		
											9-39		
											APR 15 2015		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions															
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance															
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect															
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Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing															
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish															
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Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :																					
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Picklist Print

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Page 2

Work Order ID: 131558

131558

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 4/14/2015

Required Date: 4/17/2015

Start Qty: 1.00

Required Qty: 1.00

D3239-1

Manufactured No

110

Each

13.0000

2

2

D3239-1

Cover

**

DAS
27
APR 15 2015



Location

Loc Qty

Loc Code

ST031

13

5

~~127364~~

7

6

110

Each

2.0000

1

1

D412-709-013

Manufactured No

D412-709-013

Escape Panel Push-Out Window Clear Fits LH or RH

CHG 001

**

DAS
27
APR 15 2015



Location

Loc Qty

Loc Code

FG016

2

120137

2

110

Each

1,575.000

2

2

MS21042L3

Purchased

No

MS21042L3

Nut

**

DAS
27
APR 15 2015



Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

722

M13131

722

ST305

433

116549

12

126333

49

M128754

2

M131624

370

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
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Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Picklist Print

Tuesday, April 14, 2015 1:42:42 PM

Page 3

Work Order ID: 131558

131558

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 4/14/2015

Required Date: 4/17/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

110

Each

385.0000

3 3

DAS

27

9-89

MS21042L6

Nut

**

Location

Loc Qty

Loc Code

ST273A

200

m131624

200

ST305

1

m129909

1

t260a

184

m131317

184

MS35207-262

Purchased

No

110

Each

30.0000

2 2

DAS

27

9-89

MS35207-262

Screw

**

Location

Loc Qty

Loc Code

ST276

30

m131420

30

NAS1149D0332J

Purchased

No

110

Each

1,493.000

2 2

DAS

27

9-89

NAS1149D0332J

Washer

**

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST269

1479

m130325

880

m131624

599

NAS1149D0616J

Purchased

No

110

Each

303.0000

5 5

DAS

27

9-89

NAS1149D0616J

WASHER

**

Location

Loc Qty

Loc Code

ST269

303

122815

303

Tuesday, April 14, 2015 1:42:42 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

Tuesday, April 14, 2015 1:42:42 PM

Page 4

Work Order ID: 131558

131558

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 4/14/2015

Required Date: 4/17/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0663J

Purchased

No

110

Each

1,061.000

5 - 5

NAS1149D0663.I

Washer

DAS

27

5-59

APR 15 2015

Location

Loc Qty

Loc Code

ST260

994

M131618

994

ST269

67

M126334

67

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Ref only.
S 15/04/21

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1							D3118-3	SIGN ASSEMBLY
				1			D3136-041 ✓	WINDOW ASSEMBLY
	1						D3136-043	WINDOW ASSEMBLY
1							D3224-1 ✓	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
2							D3239-1 ✓	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1			1		1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A ✓	BOLT
2							AN960JD10L	WASHER
5							AN960JD616 ✓	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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Revision: C

Date: 06.11.27